

Work Order ID 156004

Friday, January 20, 2017 10:45:51 AM

156004

Page 1

Item ID: D206-781-341KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crew Cabin Overhead, Gray

Stop

NS?

Start Date: 2/1/2017 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 2/6/2017 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: JAN 20 2017

Tooling:

Date:

Run Start

NR1

QC: _____

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 156004

Friday, January 20, 2017 10:45:51 AM

156004

Page 2

Item ID: D206-781-341KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crew Cabin Overhead, Gray

Start Date: 2/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/6/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00				DAS 27 9-89	DAS 28 9-89	FEB 03 2017	
Packaging	Identify and pack for shipping as per PPP D206-781-141KGY Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00					DAS 21 9-89	FEB 06 2017	
Quality Control									

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, January 20, 2017 10:45:56 AM

Page 1

Work Order ID: 156004

156004

Parent Item: D206-781-341KGY

D206-781-341KGY

Parent Item Name: Crew Cabin Overhead, Gray

Start Date: 2/1/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev.A New Issue 10/11/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4116-1KGY *D4116-1KGY* Panel W/Rotor Brake		Manufactured	No			110	Each	0.0000	1	1			
NAS388-6-8P *NAS388-6-8P* SCREW		Purchased	No			110	Each	23.0000	4	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st549			23					
					m131340			23					
NAS391B6P *NAS391B6P* Washer		Purchased	No			110	Each	69.0000	4	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st549			69					
					m131340			69					

DAS
28
9-89

DAS
28
9-89

D/
2
9-89

** 1

** 4

** 4

156005

FEB 0 2 2017

FEB 0 3 2017

DAS
27
9-89
DAS
6
9-89
DAS
27
9-89

FEB 0 2 2017

DAS
27
9-89
DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

5.0 PARTS LIST

5.1 BELL 206 L/L1

5.1.1 D206-781-311 UTILITY KIT

Qty -311	Part Number	Description
X	D206-781-311	UTILITY KIT
1	D206-781-341	CREW CABIN OVERHEAD KIT
1	D206-781-351	VERTICAL TUNNEL KIT
1	D206-781-361	REAR OVERHEAD KIT
1	D206-781-371	HAT BIN KIT

5.1.2 D206-781-341/-351/-361/-371 KITS

Qty -341	Qty -351	Qty -361	Qty -371	Part Number	Description
X				D206-781-341	CREW CABIN OVERHEAD KIT
	X			D206-781-351	VERTICAL TUNNEL KIT
		X		D206-781-361	REAR OVERHEAD KIT
			X	D206-781-371	HAT BIN KIT
1				D4116-1	OVERHEAD PANEL W/O DUCT
4				NAS388-6-8P	SCREW
4				NAS391B6P	WASHER
	1			D3828-1	VERTICAL TUNNEL, LOWER LH
	1			D3828-2	VERTICAL TUNNEL, LOWER RH
	1			D3829-1	VERTICAL TUNNEL W/O DUCT, UPPER LH
	1			D3829-2	VERTICAL TUNNEL W/O DUCT, UPPER RH
	1			D3829-3	VERTICAL TUNNEL W/O DUCT, AFT
	1			D3970-3	FIRE EXTINGUISHER COVER W/O DUCT
	4			D3800-1-100-800	LOOP STRIP
	4			D3800-3-100-800	HOOK STRIP
	1			D3989-1-360	SEAL
	6			MS21059L3	NUTPLATE
	12			MS20426AD3-4	RIVET
	6			AN525-10R14	SCREW
		1		D4075-1	REAR OVERHEAD, CENTER
		1		D4076-1	REAR OVERHEAD, LH
		1		D4076-2	REAR OVERHEAD, RH
		14		D4291-1	SPACER
		14		AN525-10R30	SCREW
			1	D3845-1	HAT BIN
			6	D3851-1	DOUBLER
			4	AN525-10R14	SCREW